

Work Order ID 152978

152978

Page 1

Monday, November 07, 2016 4:07:39 PM

Item ID: D3763-043

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: End Fitting Assembly, LH

Start Date: 11/1/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/7/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

DAS
21
9-89

Date: NOV 09 2016 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3763

Rev B

100

Pick Kit

0.00

100

Packaging

Memo

0.00

2 EL 16-11-09

Packaging

110

Large Fab

0.00

110

Large Fab

Memo

0.11

2 EL 16-11-09

Large Fab

1-make a 0.063" chamfer on D3763-1 fitting before ass'y2-assemble and tack weld as per dwg D3763 using locating pin DT9039 *****look at dwg before assembling parts (LH)***** remove pin before welding*****3-weld as per dwg D3763 QSI004 Alum M129399

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

120

QC

Memo

0.00

2 16-11-30 DAS
9
9-89

Quality Control

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
				OTHER :					

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

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Environment ☐	☐	No Re-verification ☐		☐	Pressure/Forced	☐	Temperature/Cure
Design ☐	☐	Operator ☐		☐	Bending	☐	Set-up
Doc/Data ☐	☐	Offset/Setup ☐		☐	Centre Not Concentric	☐	BOM/Route
Equip/Tooling ☐	☐	Supplier ☐		☐	Cracks	☐	Broken/Damage/Defect
Handling/Pre ☐	☐	Training ☐		☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified
Material ☐	☐	Use for Testing ☐		☐	Cuffs	☐	Contamination
Internal Transport ☐	☐	Poor Information ☐		☐	Crushing	☐	Countersink
Tribal Knowledge ☐	☐	Rushing ☐		☐	Heat Treat	☐	Cut Too Short
LOA ☐	☐	Product Improvement ☐		☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear
Substation ☐	☐	Process Improvement ☐		☐	Marks/Chatter	☐	Drill Holes
Past Expiry Date ☐	☐	Manufacturing Process ☐		OTHER :			
Misidentified ☐	☐	Past Due ☐					

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152978

Page 3

N900040100

Setup Start *NS1*

Stop ***NS2***

?

Cust Item ID:

Start Date: 11/1/2016 **Start Qty:** 2.00

?

Customer:

Required Date: 11/7/2016 **Req'd Qty:** 2.00

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160 Identify as per dwg & Stock Location: 51257

0.00

160

Packaging

Memo

0.00

Packaging

2

DEC 02 2016

DAS

6
9-89

170	QC21- Final Inspection - Work Order Release	0.00
-----	---	------

170

QC

Memo

0.03

Quality Control

DAS
21
9-89

DEC 05 2016

MF
10-12-05

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
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Required Qty: 2.00

2

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

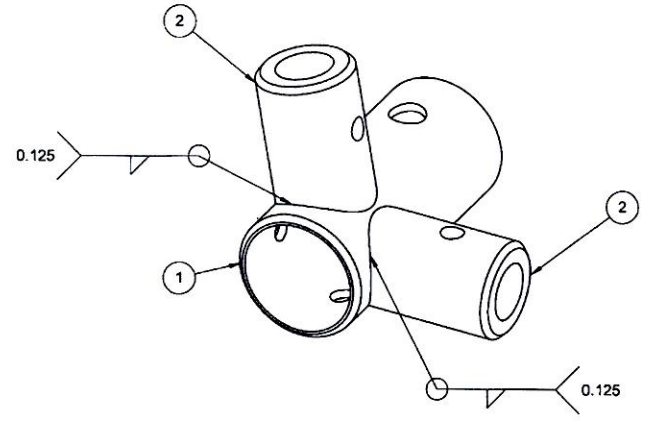
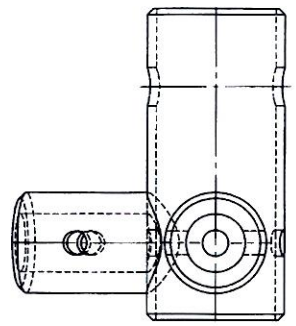
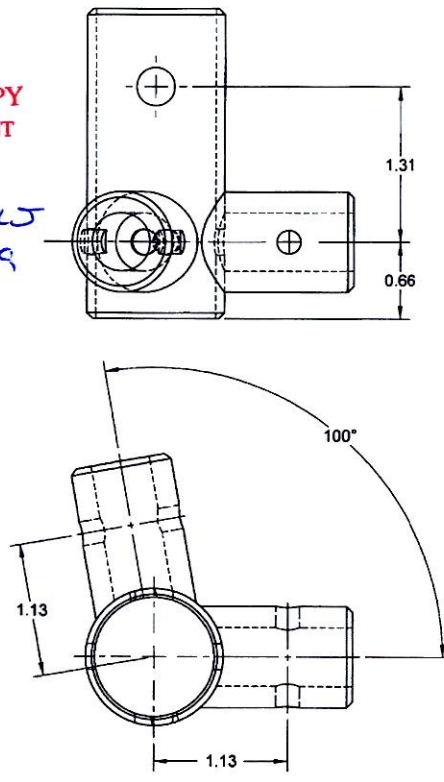


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Work Order update only ☐

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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 152978MLJ
1611-09



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3763-5	TUBE	1
2	D3763-1	FITTING	2

D3763-043 END FITTING ASSY, LH

RELEASED
08-01-10

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.05 lbs
 - 8) WELD: PER DART QSI 004

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	HS	
CHECKED		DRAWING NO. D3763
MFG. APPR.		REV. B SHEET 2 OF 8
APPROVED		TITLE END FITTING
DE APPR.		SCALE NTS
DATE	08.06.23	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.